



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G25031-3G
Job Sheet 168582



Part No: RBW6205G25031-3G

Job Qty: 1 ea

Part Name: Clamp Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/17/17

Job Tracking No:

Due Date: 12/1/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/1/17	0.00	0.00	Start Up Container		<i>SS 18-01-23</i>
110	Small Fab	1 pcs		12/1/17	0.00	0.00	Small Fab		<i>SS 18-01-23</i>
120	QC	1 pcs		12/1/17	0.00	0.00	QC5		<i>38</i>
130	Packaging	1 pcs		12/1/17	0.00	0.00	Packaging3 <i>GA</i>		<i>AT 18/01/23</i>
140	QC21-SA	1 Ea		12/1/17	0.00	0.00	QC21		<i>AT 18/01/23</i>

Part Op 110 - 1-Assemble as per DWG. Sheet 1 2-Install -3 protection onto -1 clamp using adhesive. Drill 0.09 holes at assembly
Descriptions: and stretch tight. As per DWG. note 3. B; _____ EXP: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	91793A076	4	100	0	0
	RBW6205G25031-3G-1 <i>A-205</i>	1	0	0	0
	RBW6205G25031-3G-3	1	0	0	0

Part Specifications

Specifications could not be found.

Plex 11/17/17 11:43 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____ Step #: _____

Descr

**S034707****Clamp Assembly****Dart Aerospace Ltd.**
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

MRB (QSI042) Approval

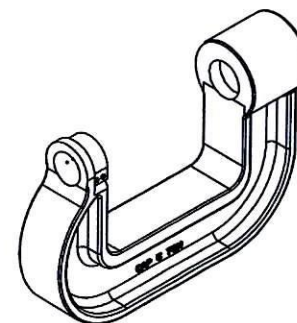
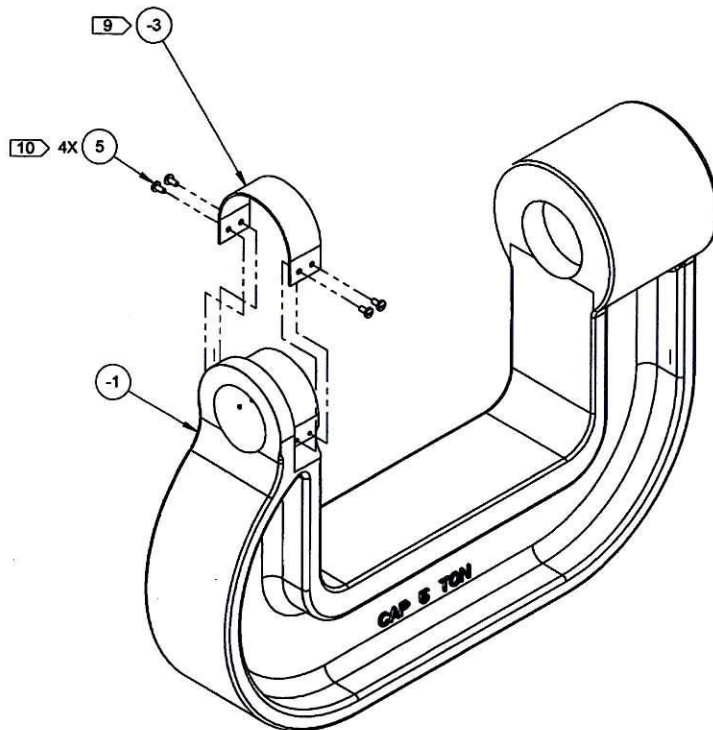
Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval
PART NO: RBW6205G25031 - 3G
Original Serial #: S034707
Revision:
Operation:
Change No:
Start up Operation 01/23/18**Job No: 168582**

Root Cause							
Environment ☐	No Re- ☐	Clamp/kink/kipple/wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Positioned Wrong ☐		
Design ☐	Operat ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/ ☐	Crushing ☐	Countersink ☐	Off-set ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplie ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐				Drawing ☐		
Tribal Knowledge ☐	Rushing ☐				Finish ☐		
LOA ☐	Product Improvement ☐				Misread ☐		
Substation ☐	Process Improvement ☐				Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER : ☐					

ITEM #	QTY	PART #	DESCRIPTION	PG
-1	1	RBW6205G25031-3G-1	CLAMP	2
-3	1	RBW6205G25031-3G-3	PROTECTION	3
5	4	MCMaster-CARR 91793A076	#2-56 x 3/16" BINDING HEAD SCREW	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	RELEASED FOR PRODUCTION		16/05/2017	DPD	JAG
B	UPDATED -1 CLAMP GEOMETRY PER PHOTOS, REMOVED NOTE 3 ADHESIVE, ADDED THREADLOCKER TO ITEM 5	17-701	10/10/2017	SAC	WM



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168582 MW
17-11-17

RBW6205G25031-3G CLAMP ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A
 - 7) REF. AGUSTA T/N: 3G6205G25031
 - 8) PART OF KIT: RBW6205G21631-3G
 - 9) DRILL $\phi .09$ " HOLES IN -3 AT ASSEMBLY AND STRETCH TIGHT
 - 10) APPLY LOCTITE 222 THREADLOCKER TO THREADS

DART AEROSPACE		Newbury, Ontario, Canada	
CLAMP ASSY			
Dwg No. RBW6205G25031-3G		REV B	
DESIGN BY:	DPD 16/05/2017	XXX 2 505 FRACTIONS & 1/8	
DRAWN BY:	SAC 10/10/2017	XX 2 51 ANGLES & 1/8	
CHECKED:	VM 10/10/2017	X 2 1 SURFACES & 1/8	
INFO. APPL:	DP 10/10/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 10/20/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	18/10/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	SHEET 1 OF 3
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DQA: _____ Date: _____



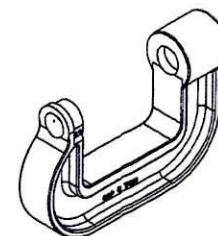
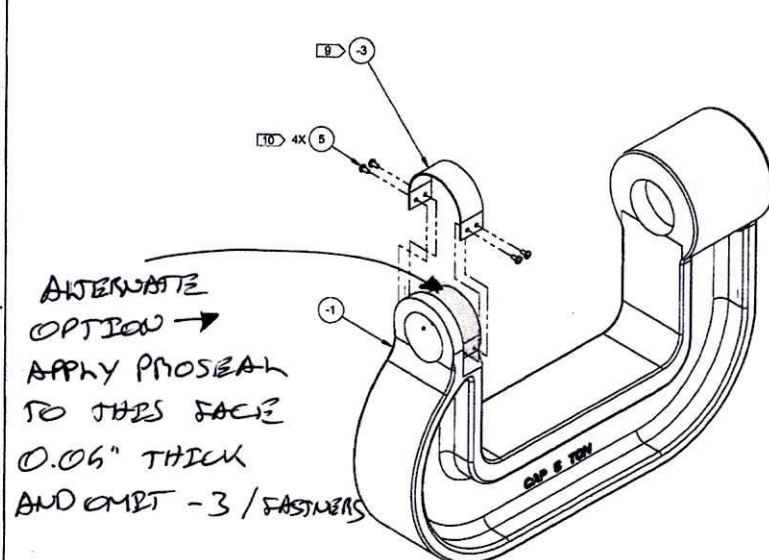
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coor. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER :																									

ITEM #	QTY	PART #	DESCRIPTION	PG	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-1	1	RBW6205G25031-3G-1	CLAMP	2	1	RELEASED FOR PRODUCTION		16/05/2017	DPD	JAG
-3	1	RBW6205G25031-3G-3	PROTECTION	3	B	UPDATED -1 CLAMP GEOMETRY PER PHOTOS, REMOVED NOTE 3 ADHESIVE, ADDED THREADLOCKER TO ITEM 5	17-701	10/10/2017	SAC	WM
5	4	MCMASTER-CARR 91783A078	#2-56 x 3/16" BINDING HEAD SCREW	-						



DART AEROSPACE	
Middletown, Ontario, Canada	
TITLE: CLAMP ASSY	
REV. NO.:	REV. B
PART NO. RBW6205G25031-3G	
DESIGN BY:	DPD 18/05/2017
DRAWN BY:	SAC 10/10/2017
CHECKED BY:	WM 10/10/2017
APPROVED BY:	WM 10/10/2017
DATE:	10/10/2017
SCALE:	1:1
SHEET 1 OF 3	

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A
 - 7) REF. AGUSTA T/N: 3G6205G25031
 - 8) PART OF KIT: RBW6205G21631-3G
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